



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBT18520-9
Job Sheet 201169



Part No: RBT18520-9

Job Qty: 4 pcs

Part Name: Extension



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/26/19

Job Tracking No:

Due Date: 11/11/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG RBT18520 Rev Q IPP REV A 18.02.07 NEW ISSUE RQ VERIFIED BY DP/IPP Rev. B 19.02.22 drawing revision DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Conventional Lathe - 1	4 pcs		11/11/19	0.00	0.50	Conventional Lathe - 1		
							Conventional Lathe - 2		
130	QC 2	4 pcs		11/11/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S221779



Part: RBT18520-9

Job No: 201169

Serial No/Batch: S221779

Revision: Q

Inspector:

Exp Date:

Instructions:

Date: 10/11/19

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140 QC 8 4 11/11/19 0.00 0.00
pcs

QC 2 - 64

QC 2 - 65

QC 2 - 5

QC 2 - 71

QC 2 - 73

QC 2 - 69

QC 8 - 12

QC 8 - 14

QC 8 - 17

QC 8 - 20

QC 8 - 25

QC 8 - 3

QC 8 - 32

QC 8 - 33

QC 8 - 35

QC 8 - 39

QC 8 - 4

QC 8 - 44

QC 8 - 45

QC 8 - 49

QC 8 - 58

QC 8 - 8

QC 8 - 9

QC 8 - 68

QC 8 - 67

QC 8 - 1 (A)

QC 8 - 47

QC 8 - 40

QC 8 - 52

QC 8 - 23

QC 8 - 57

QC 8 - 76

QC 8 - 61

Handfinish - 7 - 1 -
B4BHandfinish - 7 - 2 -
B4B

QC 5 - 10

QC 5 - 12

QC 5 - 17

QC 5 - 18

QC 5 - 19

QC 5 - 22

QC 5 - 24

QC 5 - 3

QC 5 - 43

QC 5 - 49

QC 5 - 51

QC 5 - 58

QC 5 - 68

QC 5 - 9

QC 5 - 50

QC 5 - 30

QC 5 - 40

QC 5 - 61

QC 5 - 81

142 Handfinish - 7 - 1 -
B4B

143 QC 5

step

142, 143

not required

19-10-11

* See Pec's to omit
these 2 steps for this time

150 Outsource - 12 - Black Oxide 4 11/11/19
pcs

GRO002-VC 10

160 Packaging 2-1 - Receive - B4B 4 11/11/19
pcs

Packaging 2 - 1 - B4B

Packaging 2 - 2 - B4B

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9/26/2019

[Dart Hawkesbury] Job Sheet - Lajeunesse, Marie

				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	OP OCT 2 5 2019
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 - B4B	
				Packaging 2 - 16 - B4B	
				Packaging 2 - 17 - B4B	
				Packaging 2 - 18 - B4B	
				Packaging 2 - 19 - B4B	
				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170 QC 6	4 pcs	11/11/19	0.00 0.00	QC 6 - 9	DAS
				QC 6 - 68	OCT 30 2019 68
				QC 6 - 61	9-89
				QC 6 - 40	
				Plex 9/26/19 12:59 PM Dart.lajeunesse.marie	

			QC 6 - 81		
180	Packaging 3-1 - Stock - B4B	4	11/11/19	0.00 0.00	Packaging 3 - 1 - B4B
		pcs			Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
190	QC 21 - SA	4	11/11/19	0.00 0.00	QC 21 - SA - 21
					Plex 9/26/19 12:59 PM Dart.lajeunesse.marie

pcs	QC 21 - SA - 70	
	QC 21 - SA - 53	

Part Op 120 - Manufacture as per dwg

Descriptions: 130 - QC2- Inspect parts off machine FAI/FAIB
 140 - QC8- Inspect parts - second check
 142 - Bead Blast - Remove scale
 143 - QC5- Inspect part completeness to step on W/O
 150 - -Issue P/O to Groupe Altech; PO 44777 -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required
 160 - Receive & Inspect for Damage & Mat'l Certs
 170 - QC6- All purchased or subcontracted products
 180 - Identify as per dwg & Stock Location: _____
 190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
7767T61	Low-Carbon Steel Round Tube, 0.188" Wall Thickness, 3/4" OD	4.1867 ft (1.04667 ea)	120-Conventional Lathe - 1	<u>S2M120</u>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Conventional Lathe - 1	7767T61	4	3	0

Part Specifications

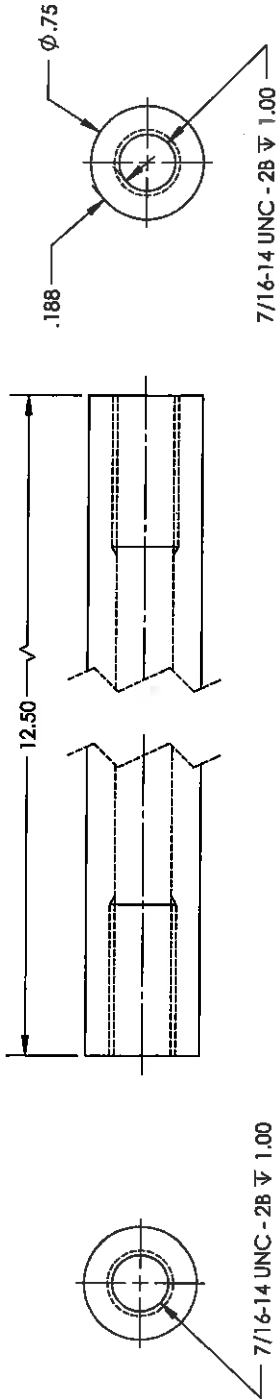
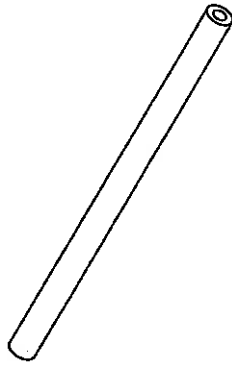
Specifications could not be found.

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REVISIONS			
REV	ECR	DESCRIPTION	DATE
10	14-0096	-9 CHD DIM WAS .188 WALL IS .19.	8/4/2016
Q		MATERIAL WAS CUS IS A513 TYPE 5 DOM TUBING. DIMENSION WAS .19 IS .188, FINISH SPEC CHANGED.	2/19/2019

INITIAL	APPROVED
DPD	JAG
VM	VM



TITLE M/R DAMPER LOAD TEST DEVICE

DPWG NO. RBT18520-9

REV Q

UNLESS OTHERWISE SPECIFIED	
MATL	A513 TYPE 5 DOM TUBING
FINISH	BLACK OXIDE
SPEC	SEE DRAWING
DRAWN BY:	COLE
CHECKED:	MACKOVIAK
QA APPR:	ANDERSON
APPROVED:	LINDSAY
SCALE	N/A
DATE	8/17/2000
SHEET	9 OF 17

EXTENSION

SHOP COPY

UNCONTROLLED

WITHOUT NOT
WORK ORDER

201165 M15

14-09-26

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐



Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				MRB (QSI042)																															
Date: _____		Sequence #: _____		QTY Affected: _____		MRB (QSI042)																																	
Description Work Order Deviation						Disposition																																	
Completed By						Lead hand / Supervisor																																	
						QC / QA Coordinator																																	

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐						FAULT CATEGORY <table border="1"> <tr> <td>Pressure/Forced</td> <td>Contamination</td> <td>Power Loss/Surge</td> <td>Positioned Wrong</td> </tr> <tr> <td>Bending</td> <td>Misaligned/off center</td> <td>Folio/Program</td> <td>Outside Tolerance</td> </tr> <tr> <td>Crushing</td> <td>BOM/Route</td> <td>Grain Direction</td> <td>Drawing</td> </tr> <tr> <td>Cracks</td> <td>Broken/Damage/Defect</td> <td>Weld</td> <td>Finish</td> </tr> <tr> <td>Crimp/Kink/Ripple/Wave/Twist</td> <td>Incomplete/Unclear Instructions</td> <td>Wrong Stock Pulled</td> <td>Part Lost/Missing</td> </tr> <tr> <td>Marks/Chatter</td> <td>Drill Holes</td> <td>Out of Sequence</td> <td>Misread</td> </tr> <tr> <td>Mislabeled</td> <td>Fit/Function</td> <td>Off-set/Set-up</td> <td></td> </tr> </table>						Pressure/Forced	Contamination	Power Loss/Surge	Positioned Wrong	Bending	Misaligned/off center	Folio/Program	Outside Tolerance	Crushing	BOM/Route	Grain Direction	Drawing	Cracks	Broken/Damage/Defect	Weld	Finish	Crimp/Kink/Ripple/Wave/Twist	Incomplete/Unclear Instructions	Wrong Stock Pulled	Part Lost/Missing	Marks/Chatter	Drill Holes	Out of Sequence	Misread	Mislabeled	Fit/Function	Off-set/Set-up	
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Other/Details:						_____																																	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER POHB044777



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044777

PO Date: 10/15/19

Due Date: 10/23/19

**Purchase Order
Revision:**

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

EMAILLED
2019-10-21

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201265	RB T101308-1	RB T101308 RevA	Jack Screw -Issue P/O; -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type; 4140 -Certificate of Conformity is required	Firmed	-	10/23/19	7 pcs	0 pcs	7 pcs	\$0.89/pcs	\$6.23
2	200271	RBE350A94-3700-A-01	RBE350A94-3700-A Rev 7	Tube -Issue P/O to Groupe Altech -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/23/19	42 pcs	0 pcs	42 pcs	\$3.87/pcs	\$162.54
3	201169	RBT18520-9	RBT18520 Rev Q	Extension -Issue P/O to Groupe Altech; PO -Black oxide finish, MIL-C-13924C Class 1 -Certificate of Conformity is required	Firmed	-	10/23/19	4 pcs	0 pcs	4 pcs	\$4.35/pcs	\$17.40



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PURCHASE ORDER **POHB044777**



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	196882	RB6796941	RB6796941 Rev 11	Seals Replacement, Accessories Gear Box -Issue P/O; ***parts are to be stripped first*** -Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-C-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. -Material type 1144 stress proof -Certificate of Conformity is required	Firmed	-	10/23/19	2 pcs	0 pcs	2 pcs	\$120.00/pcs	\$240.00
<i>W/O 196882 is with Steven Drouin</i>												
Line Item Note RB6796941-17 x 2 pcs RB6796941-18 x 2 pcs sent for re-work												

Grand Total: \$426.17

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/21/19 12:58 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(023281-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupealtech.com

Bon de Livraison / Packing Slip

023281 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
24-Oct-2019		Jigar Patel		POHB044777				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir / Back Order
1	RBT101308-1 Rev.A	RB T101308 01 -OXIDE-BLK & OIL [OXIDE BLACK AND OIL] MIL-C-13924C CLASS 1 APPLY THIN LAYER OF OIL/CPC PER MIL-PRF-16173 GRADE 3 CLASS 1 OR MIL -C-81309 TYPE 3 OR MIL-C-23411A OR MIL-PRF-81309 AND WIPE OFF EXCESS	OXIDE-BLACK CH	7	7	0	0	0
2	RBE350A94-3700-A-01 Rev.7	RBE350A94-3700-A 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	BLACK-OXIDE CH	42	42	0	0	0
3	RBT18520-9 Rev.Q	RBT18520 01 -OXIDE BLACK [OXIDE BLACK] MIL-C-13924C CLASS 1	OXIDE-BLACK CH	4	4	0	0	0

RECEIVED
 OCT 24 2019
 DART AEROSPACE LTD.

DAS
68
9-29

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.